

Date: Thursday, 27/11/2008 4:02:49 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: HANDLE WELDMENT		
Job Number	: 43799			Part Number	: D2530		
Estimate Number	: 10333			Drawing Number	: D2530 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 27/11/2008 S.O. No. :			Drawing Revision	: B		
Prsh Rev.	: NC			Material	:		
First Issue	: 27/11/2008 Type : SMALL /MED FAB			Due Date	: 20/12/2008 Qty: 20 Um: Each		
Previous Run	: 40758			Comment	: Est Rev:E Removed Purchasing 05-11-07 JLM		
Written By	:						
Checked & Approved By	: <u>DAO 08-11-27</u>						
Comment	: Est Rev:E Removed Purchasing 05-11-07 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 3.0602 f(s)/Unit Total : 61.2045 f(s) Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049) Batch: <u>M109314</u>	SAB 08-12-18 20
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		1-Cut to length as per Dwg D2536	
		2-Deburr	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	S 08/12/18 (X2L) counter
4.0	D2534	Lock Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s) Pick: QTY Part # Description Batch 2 D2534 Lock Plate 18X B40212 24X B43843	EL 8-17-23 X(42)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301	

M107051EL 8-12-31 (X2L)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

2-Deburr

6.0 QC9

VISUAL WELDING INSPECTION



Cpl08 01.06



(21)

Comment: VISUAL WELDING INSPECTION

7.0 QC5

INSPECT WORK TO CURRENT STEP



counters
S 08(01.06 YCL)

Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING

POWDER COATING



m105642



(21)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 7:20

OVEN TEMPERATURE: 320°

FINISH TIME: 7:50

Fd 09/01/09

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(21X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 PACKAGING 1

PACKAGING RESOURCE #1



(21)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 204

M-1

09/01/09

(21)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



09/01/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-09

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

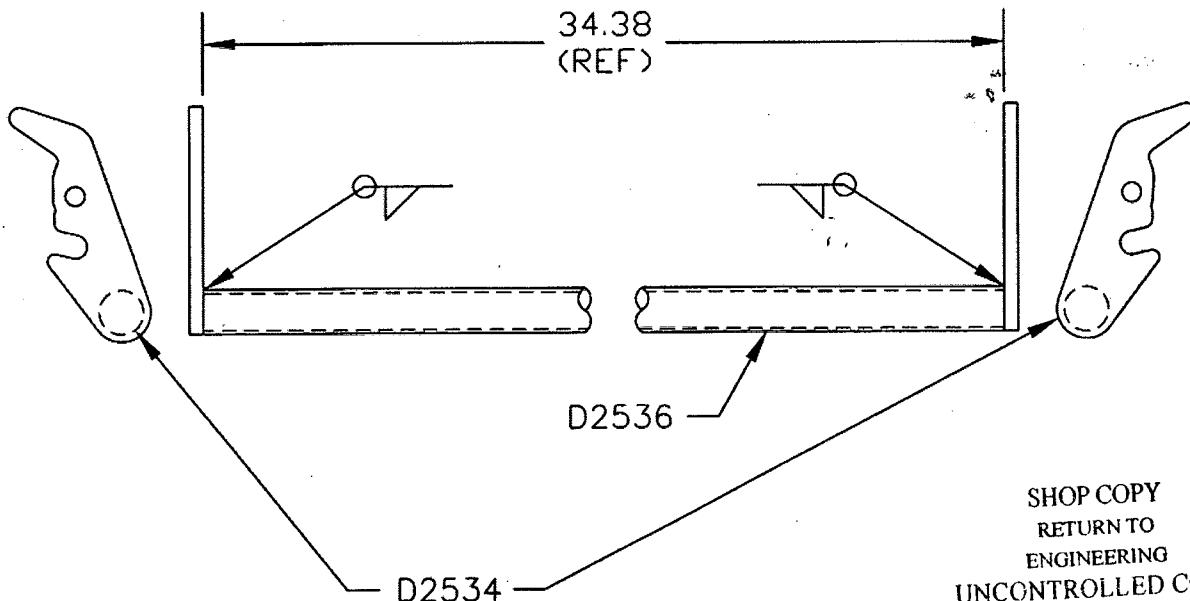
DART

DESIGN B. WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2530
		REV. B SHEET 1 OF 1
DATE 04.12.14		TITLE HANDLE WELDMENT
A	96.06.18	SCALE NEW ISSUE
B	04.12.14	UPDATE NOTES AND DIMENSIONS

RELEASED

04.12.16 *[Signature]*PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43799

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

